



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-3400

D4635-144
Job Sheet 167086-K



Part No: D4635-144 **REV F 10 9-89** Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	<i>D.M.L 18-3-28</i>
100	HandThermo	1 pcs		11/9/17	0.00	1.16	HandFinish4	<i>Not Required</i>
110	Small Fab	1 pcs		11/10/17	0.00	1.57	Small Fab	<i>DAS 18/03/28</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>51 SM 18-3-28</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>28/1/18-3-28</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>mjs 18/03/28</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer (see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-4 <i>5053616</i>	1	2	0	0
	D4669-1 <i>5009911</i>	1	27	0	0
	D4695-4 <i>5005045</i>	1	2	0	0
	D4732-11 <i>5008989</i>	1	5	0	0
	D4732-39 <i>5009005</i>	1	6	0	0
	D4732-41 <i>5009008</i>	1	6	0	0
	D5022-5 <i>5017750</i>	1	2	0	0

Part Specifications

Specifications could not be found.

5002018

Plex 10/24/17 11:09 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____	DISPOSITION Rework ☐ Scrap ☐	Skid-tube ☐ Machining ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; text-align: center;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐																																																																																																							
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 1270 Aberdeen Street
 Newmarket, ON N8B 1K7
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 Email: sales@dartaero.com
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Container No: S055835



Part: D4635 - 144

Job No: 167086 - K

Serial No/Batch: S055835

Revision: F

Inspector:

Date: 03/28/18